

Date: Thursday, 18/09/2008 11:41:24 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: REPLACEMENT WINDOW ASSEMBLY		
Job Number	: 42121			Part Number	: D3290041		
Estimate Number	: 11174			Drawing Number	: D3290 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 18/09/2008	S.O. No.	:	Drawing Revision	: C		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 25/09/2008	Qty:	12
Previous Run	: 42024			Um:	Each		
Written By							
Checked & Approved By							
Comment	: Est. B 05.05.25 Added Step 11 KJ/JLM Est. C 06.05.09 Ecn 798 EC Est Rev:D Now on Waterjet 06-06-16 JLM Est rev E rev C dwg 07.09.28 EC verified by: DD						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S040	6061-T6 .040 Sheet
<b>Comment:</b> Qty.: 3.9375 sf(s)/Unit Total : 47.2500 sf(s) M6061T6S040 Batch: <u>109396</u> <u>IB 8-9-29</u>		
2.0	WATER JET	FLOW WATER JET
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3290 ( use prog. for D3290-1) Dwg Rev: <u>C</u> <u>IB 8-9-29</u> Prog Rev: <u>C</u>		
<b>Comment:</b> 2-Deburr if necessary <u>IB 8-9-29</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>IB 8-9-29</u>		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>8 08/08/02</u>		
<b>Comment:</b> SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<u>08-12-02 x12</u>		
<b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3290-041 PAR #: N/P Fault Category: Read - Sm/Med NCR: Yes No DQA: A Date: 08-11-18  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: HJ Date: 08/11/20

NCR: 42121		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/10/20	# 20	two parts found with deep markings on them. (Scratches) in order to buff out mat. will be too thin.	<u>BS</u> 08/10/20	Scrap and Destroy and replace Qty @ B # 109396	<u>BS</u> 08-10-20	<u>BS</u> 08/10/20	<u>BS</u> 08/10/20	<u>S</u> 08/10/20
		LC <del>marking</del> marking on material when stored on <del>the</del> SHELF Mat. Rack						

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M1109152



12X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

8:40 =

OVEN TEMPERATURE:

320°

FINISH TIME:

9:10

m-h 08/10/03

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



X12

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.16.03

8.0 D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total : 78.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description Batch  
1 D2126-0780 Locking Seal B47154

SAD 08-11-15 ⑦

9.0 D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Window

Pick:

Qty Part Number Description Batch  
1 D3290-3 Window 42120

PL81414 ②

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAD

08-11-15 ②

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S081117 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST. 219

AS 08/11/17 XJ

13.0	QC21	FINAL INSPECTION/W/O RELEASE
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08/11/17 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-17

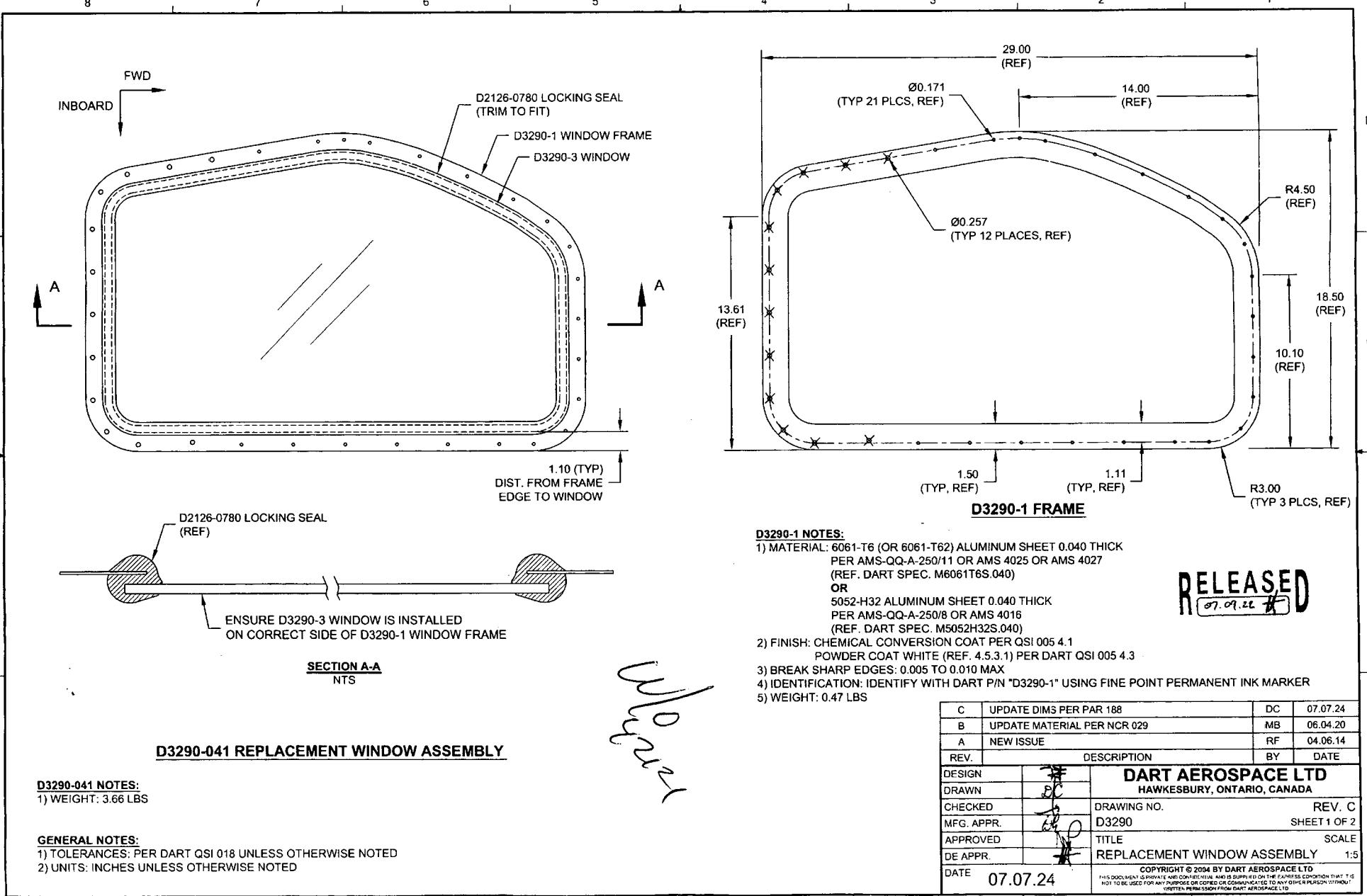
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

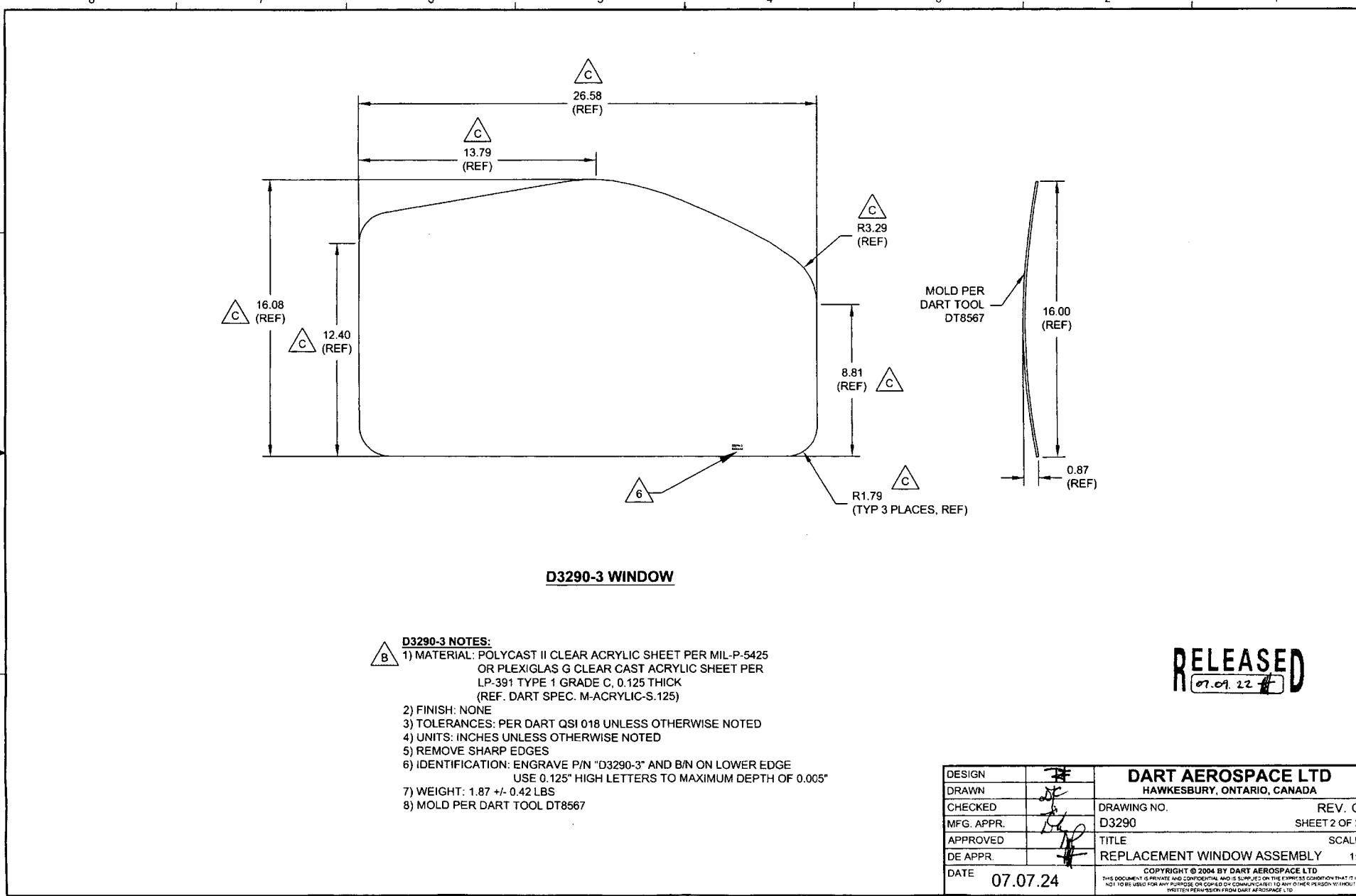
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DART AEROSPACE LTD	Work Order:	42121
Description: REPLACEMENT WINDOW ASSY	Part Number:	D3290-041
Inspection Dwg: D3290-1, Rev: C		Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article X Prototype

Measured by:	B	Audited by:	C	Prototype Approval:	N/A
Date:	8-9-09	Date:	08/10/09	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	